

D206628-034

Work Order ID 50821

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Page 1

Item ID: D2842-042

Accept

Revision ID: B

Item Name: Step Assembly RH, 206 Float

Setup Start

Stop

Start Date: 7/27/09 Start Qty: 4.00

Required Date: 7/31/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842; 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842; 3-Deburr and bevel ends for welding

SAO 09-07-23

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs as per Dwg D2842; A/R AL Rod
Batch: ~~m11072~~ m1109724
09-07-21

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

BE 09/07/28 (4)

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

⇒ 509/07/08

4420

7

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

3AD 09-07-28

4

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

1/2 09-07-29

4

QC

Memo

0.00

Quality Control

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Large Fab	Large Fab	0.00							
Large Fab	Memo 1-Remove alodine prior to welding. 11 Weld end cap as per Dwg D2842.11A/R AL Rod Batch: <u>M110130</u> 2-Grind end cap weld flush. SAD 09-07-29	0.00							
170 QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo DD 09.07.30	0.00							
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo 2) S 09/07/30 (x4RH) /	0.00							

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Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

7:30am

OVEN TEMPERATURE:

FINISH TIME:

320°F

09-07-30 X4RH 21

M112140 09-07-31 X4RH 21

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 09-08-04 21

210



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install inserts as per Dwg D2842; 2-Wing Walk as per Dwg D2842 and QSI

005 4.1 Batch:

M111013

M112106 wing walk

Batch: M111557 exp: 10/01 Si Reflex mp 09/08/04 (xy)

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Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 S 09/08/09



230

Identify as per dwg & Stock Location: _____

0.00

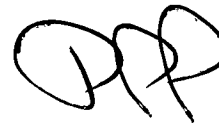


Packaging

Memo

0.00

Packaging



50817

4K SL

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/18

MF 09-08-17

Picklist Print

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Work Order ID: 50821

Parent Item: D2842-042RevB

Parent Item Name: Step Assembly RH, 206 Float

Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L

Purchased

No

100

Each

4,758.000

12.0000



washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4758

103585

100

112116

4658

110

Each

157.0000

4.0000

D2622-120CRevC1

Manufactured

No



Step Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

31

46910

31

Main Warehouse

WA

126

48612

126

110

Each

133.0000

8.0000

D2734RevC

Manufactured

No



Step End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

133

43535

17

48110

116

MD 09/08/04 x12
4 SAD 09-07-23 4
4+4 09-07-23

Picklist Print

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Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3459-1RevA		Manufactured	No			110	Each	26.0000	8.0000			
												
Float Step Mounting Plate												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

6

46987

6

HE 09.07.23 6

Main Warehouse

WA

20

48138

20

HE 09.07.23 2

D3459-3RevA

Manufactured

No

210

Each

23.0000

8.0000



Float Step Mounting Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

23

46866

6

46988

17

HE 09.07.23 8

Picklist Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039C1-07		Purchased	No			210	Each	70.0000	12.0000			



screw

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

70

107008

1

111424

69

mo 09/08/09 x 12

NAS1329C3KB130

Purchased

No

210

Each

122.0000

12.0000



insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

122

110147

22

111981

100

mo 09/08/09 *10

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Shop Packet Print

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Picklist Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L		Purchased	No			210	Each	374.0000	12.0000			
												
WASHER												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	334	
110450	2	
110806	32	
111819	300	

MO 09/08/04 X12

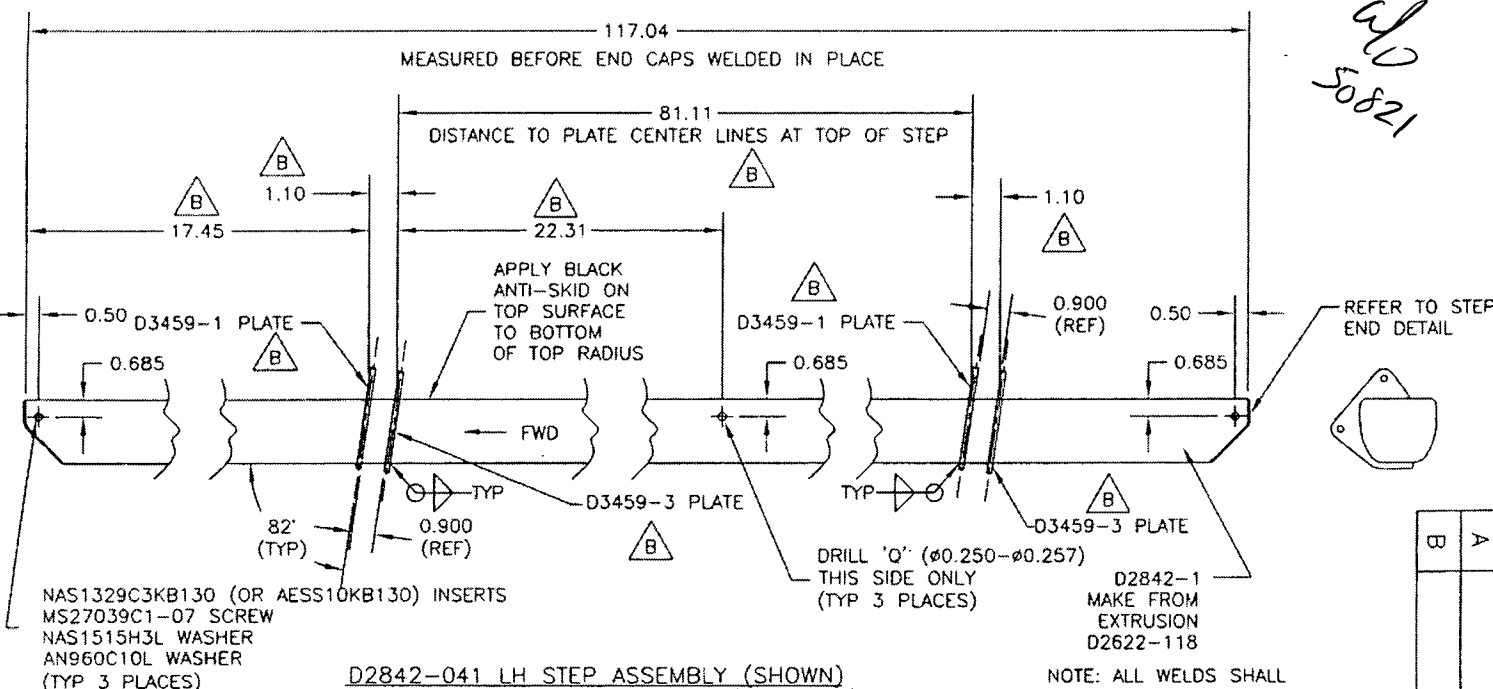
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Shop Packet Print

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DART

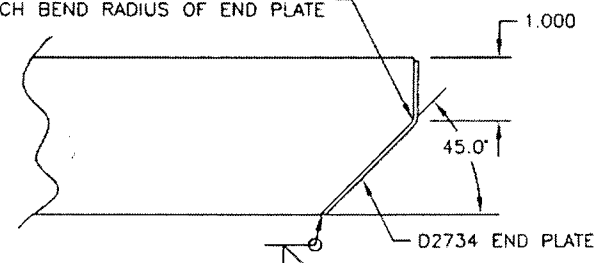
DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
			NEW ISSUE	SCALE
			RE-DESIGN, ADD D3459-1/-3	NTS



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/11/14